

Date: Monday, 30/10/2006 12:57:11 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STOP
Job Number	: 29224		
Estimate Number	: 10514		
P.O. Number	: N/A	Part Number	: D28051
This Issue	: 30/10/2006 S.O. No. : N/A	Drawing Number	: D2805 REV. B
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 27616	Material	: N/A
Written By	:	Due Date	: 30/10/2006 Qty: 6 Um: Each
Checked & Approved By	:		
Comment	: Est: B 00.11.14 Revised Finishing step to Acid etch and Alodine EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1500X01500	6061-T6 Bar 1.5" x 1.5"	
			
Comment: Qty.: 0.2756 f(s)/Unit Total : 1.6538 f(s) 6061-T6 Bar 1.5" x 1.5" Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5" (M6061T6B1500X01500) Batch: <u>916954</u> <u>ml 06/10/20</u> 6			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut Bar: 3.150" Long +0.010/-0.030" <u>ml 06/10/30</u> 6			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA104 and Dwg D2805 2- Tumble and Deburr Identify as D2805-1 <u>ml 06/10/30</u> 6 PTO			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 06/10/30</u> 6			
5.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>J.F. 06/10/31</u> 6			

Date: Monday, 30/10/2006 12:57:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 29224

Part Number: D28051

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YC 06/10/31 x 6

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

SB 06/10/31

6

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

QA
ST

06/10/31

06/10/31

3
3

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

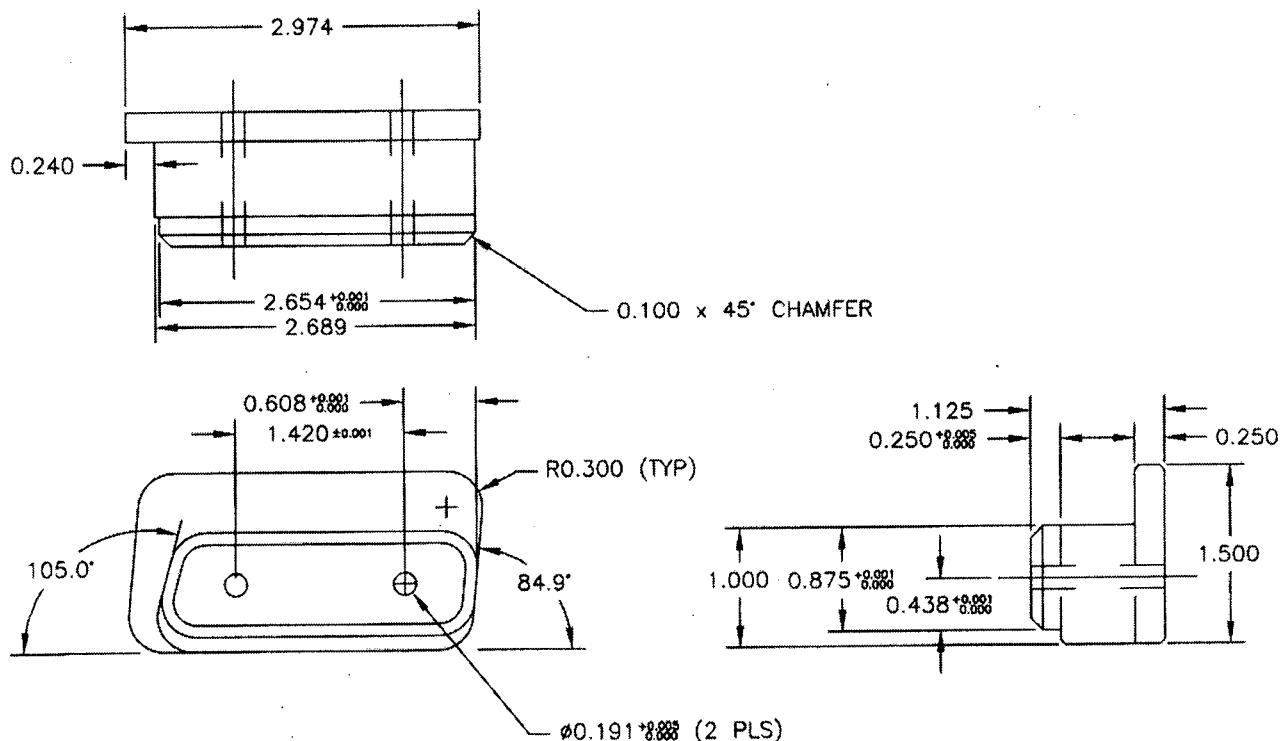
Job Completion



U 06/10/31

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2805	SHEET 1 OF 2
DATE		TITLE	SCALE
01.03.13		STOP	2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
 01.03.16 *[Signature]*

D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.

BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

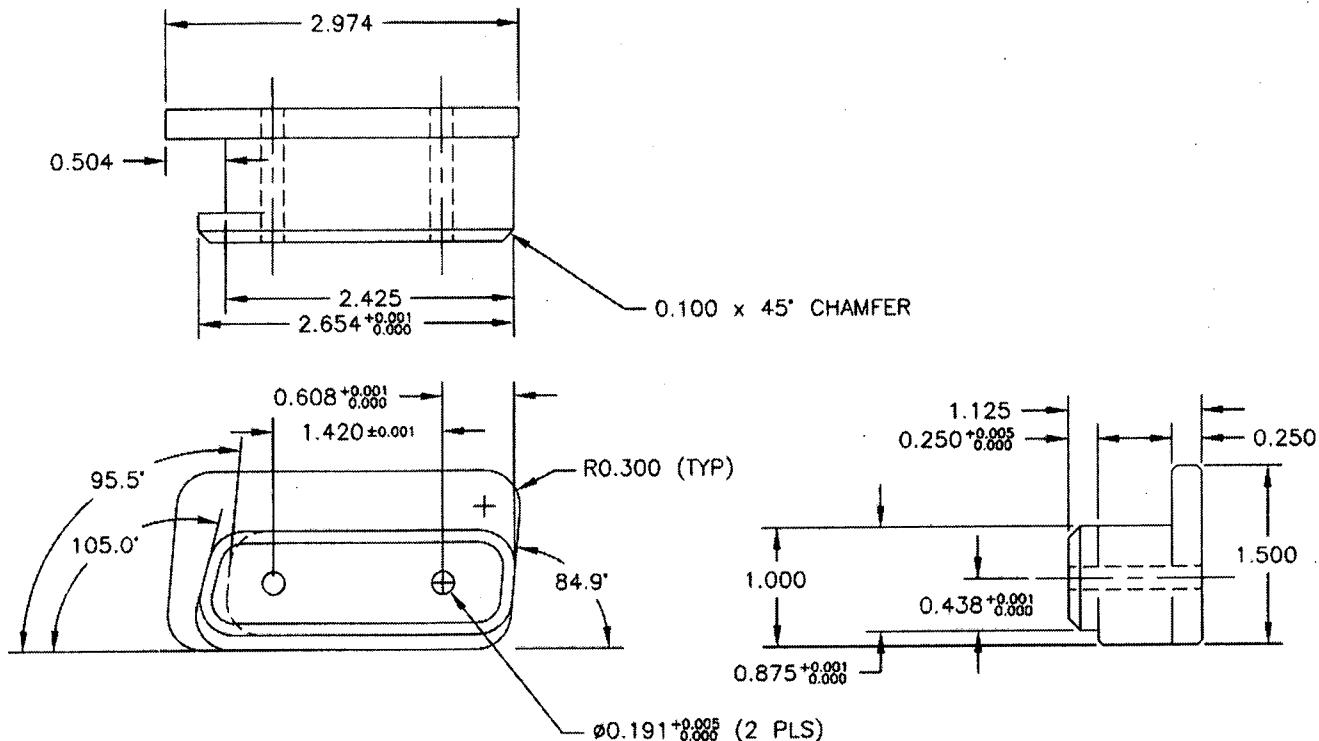
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED
01.03.16 *[Signature]*

D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	
Description: Stop	Part Number:	D2805-1
Inspection Dwg: D2805 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>ml</u>	Audited by:	<u>Er</u>	Prototype Approval:	N/A
Date:	06/10/30	Date:	06/10/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	

W/O: 29224

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/10/30	3	tried the dim. + .875 too small + .865 the E-mill would wobble	J ASW/JD	Change tools. Scrap part; destroy. Replace.			J 07/07	J 06/10/30

NOTE: Date & initial all entries